

Work Order ID 79950

February-08-12 10:13:45 AM

79950

U/R

Page 1

Item ID: D412-742-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: U/R OK 12.02.08 Stop ***NS2***
 Item Name: Replacement Float Skidtube
 Start Date: 08/02/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 22/02/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: M.C.J. Date: 12/02/08 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3391	1								

100

0.00

100

DC

Document Control

DOCUMENT CONTROL

Memo

0.00

If D412-742-043 is a W/O on it's own,
 Photocopy bluefile and create labels per PPP D412-742-043 CHG005

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 79950***79950***

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February-08-12 10:13:45 AM

Item ID: D412-742-043

Accept

N900040100Setup Start ***NS1***

Revision ID: U/R

Stop ***NS2***

Item Name: Replacement Float Skidtube

Start Date: 08/02/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 22/02/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00

110

HandFinish

Hand Finishing

HandFinishing

Memo

0.00

1-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins.
A/RSikaflex-241/-291 M114508
Expiry date: 12/08

2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Seal all bolts with sikaflex except ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex.

A/RSikaflex-241/-291 M114508
Expiry date: 12/08

3-Remove "T" pins once sikaflex is dry.

4-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.
A/RLPS Procyon M114596

1 ϕ 24 12/02/15

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 Start Date: 08/02/2012 Start Qty: 1.00 ***1*** Cust Item ID:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-742-043								
	Location: _____								
	PPP Rev: _____								

140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

⑩ SP 12-02-22

M.C. 5 12/02/22

MF 12-02-22

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Picklist Print

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Page 1

Work Order ID: 79950

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Parent Item: D412-742-043

D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 08/02/2012

Required Date: 22/02/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev A 05.10.13 New Issue KJ/JLM
 IPP Rev 06.02.13 ECN 773 dwg @ rev.D EC
 IPP Rev:C 07-05-28 As per Rev F JLM
 IPP Rev:D 07-12-04 ECN 1072 DD verified by:JLM
 IPP Rev:E 08-09-08 ecn 08-510 DD verified by:EC IPP Rev:F
 11.11.01 as per DSI9517 REV.B DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3391-021 *D3391-021* Fwd Tube Assembly		Manufactured	No			110	Each	0.0000	1	1			
									**	1377390 (x1) 12/02/15			
D3391-023 *D3391-023* Mid Tube Assembly		Manufactured	No			110	Each	0.0000	1	1			
									**	1377405 (x1) 12/02/15			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FP				1					
				GA				-1					
D3391-025 *D3391-025* Aft Tube Assembly		Manufactured	No			110	Each	1.0000	1	1			
									**	1377373 (x1) 12/02/15			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FP001				1					
				73018				1					

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Parent Item: D412-742-043

D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 08/02/2012

Required Date: 22/02/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C4A Purchased No

110 Each 3,795.000 24 24

AN3C4A

BOLT

**

24 12/02/15

Location

Loc Qty

Loc Code

ST350

3795

117313

2

117688

5

117872

10

118112

16

118451

2

119749

260

120187

2000

120423

500

120521

1000

X24

AN3C6A Purchased No

110 Each 344.0000 10 10

AN3C6A

BOLT

**

10 12/02/15

Location

Loc Qty

Loc Code

FP001

1

111982

1

ST351

343

111982

2

116419

23

116549

2

116704

12

117619

10

117688

1

117872

5

118422

13

119449

25

120423

250

X10

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Parent Item: D412-742-043

D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 08/02/2012

Required Date: 22/02/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C7A Purchased No

110 Each 85.0000 4 4

AN3C7A
BOLT

**

1118422 (x4) 12/02/15

Location

Loc Qty

Loc Code

ST351

85

113149

14

116169

1

117313

10

117619

12

117688

6

119749

42

AN960C10L NAS1149C0332 Purchased No

110 Each 0.0000 38 38

AN960C10I
washer

**

1120648 (x38) 12/02/15

D4095-041 Manufactured No

110 Each 13.0000 1 1

D4095-041
Wearplate Assembly

**

12/02/15

Location

Loc Qty

Loc Code

FP001

13

77438

3

78938

10

D4095-043 Manufactured No

110 Each 3.0000 1 1

D4095-043
Wearplate Assembly

**

12/02/15

Location

Loc Qty

Loc Code

FP002

3

77437

3

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D412-742-043

D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 08/02/2012

Required Date: 22/02/2012

Start Qty: 1.00

Required Qty: 1.00

D4095-045

Manufactured

No

110

Each

12.0000

1

1

D4095-045

Wearplate Assembly

**

42 12/02/15

Location

Loc Qty

Loc Code

FP001

12

77737

1

79042

11

41

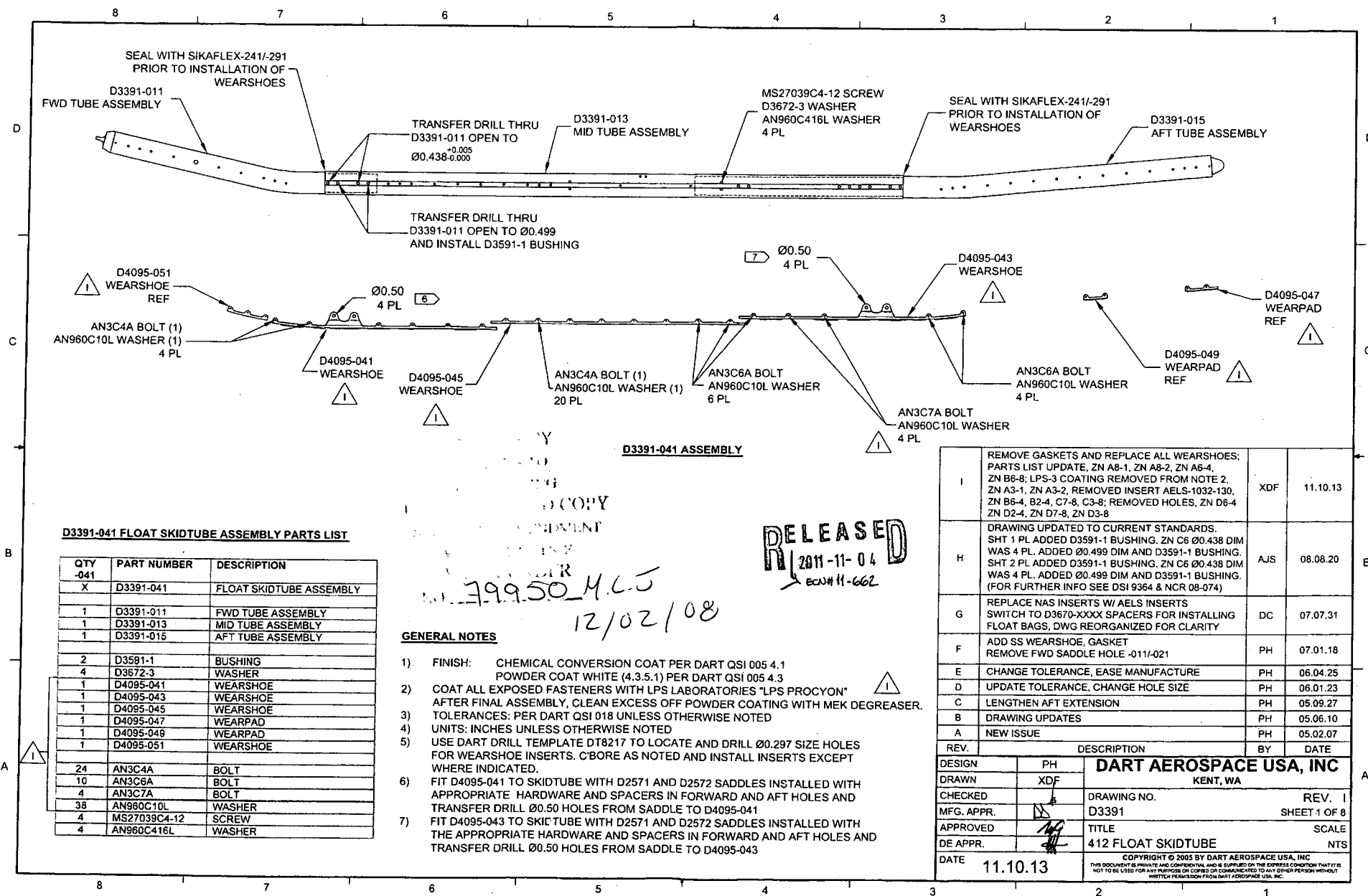
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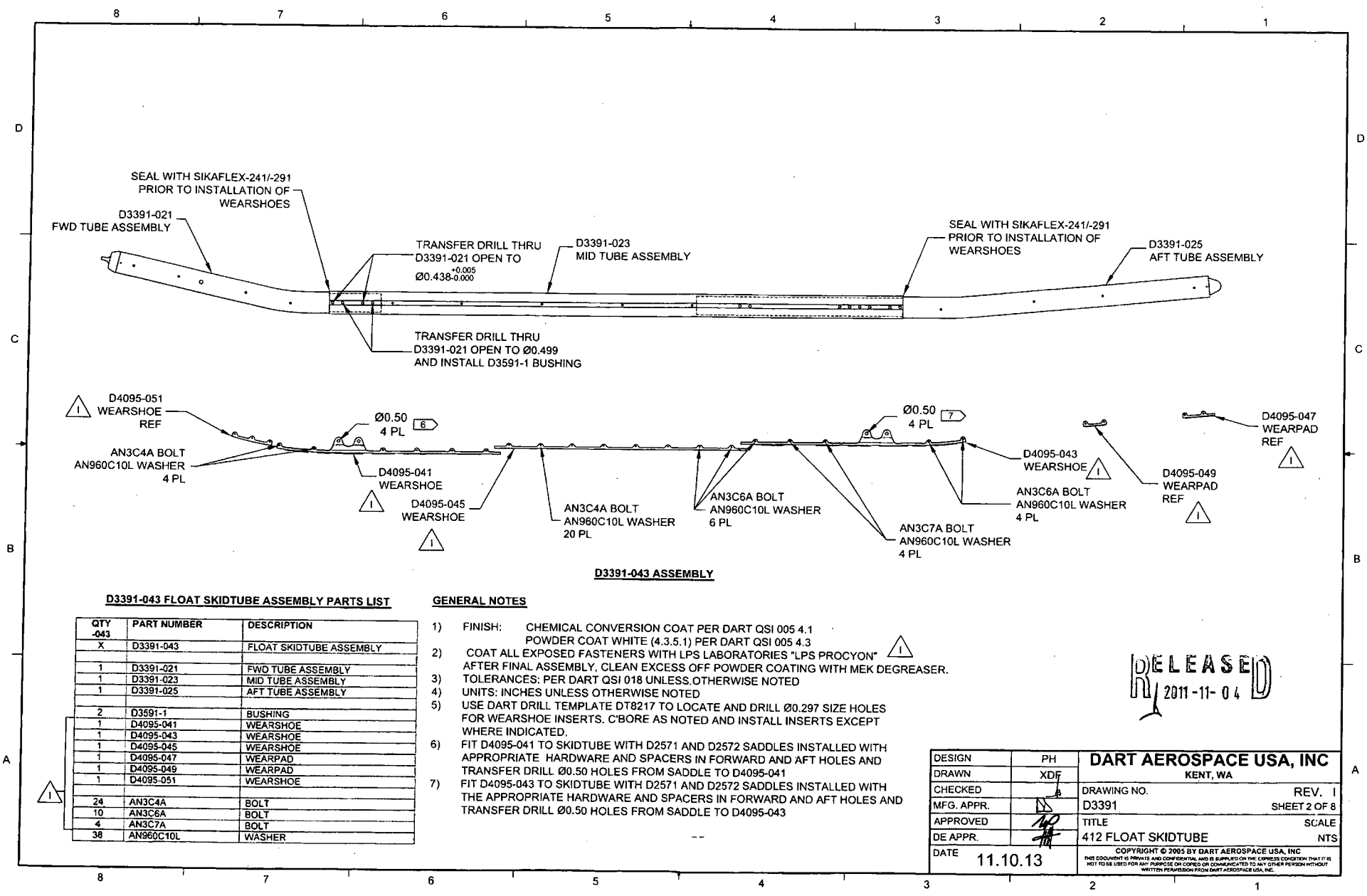
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D3391-043 ASSEMBLY

D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY -043	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARSHOE
1	D4095-049	WEARSHOE
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- 6) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 7) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

RELEASED
2011-11-04

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO.	REV. 1
MFG. APPR.		D3391	SHEET 2 OF 8
APPROVED		TITLE	SCALE
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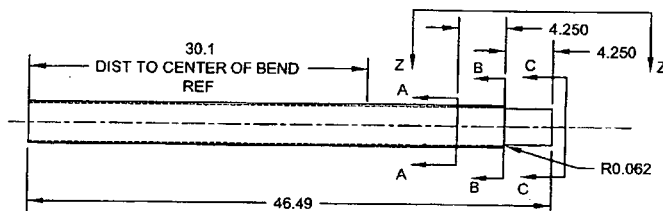
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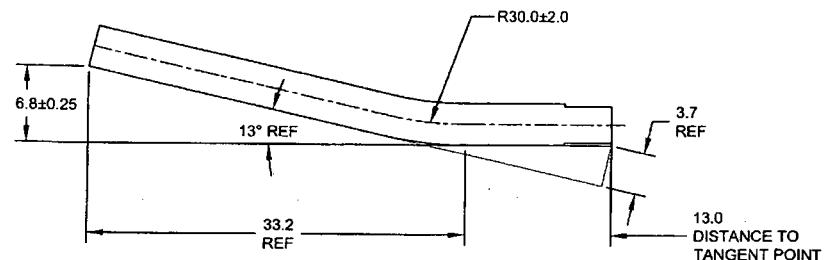
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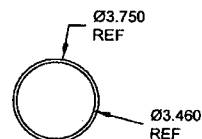
79950



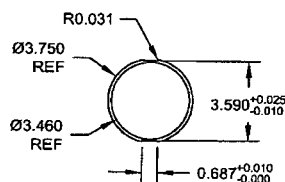
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



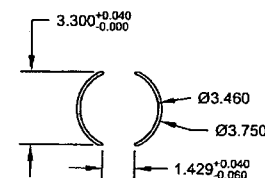
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



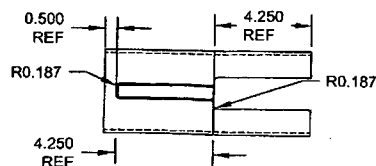
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X





SECTION C-C
SCALE 2X



VIEW Z-Z
SCALE 2X

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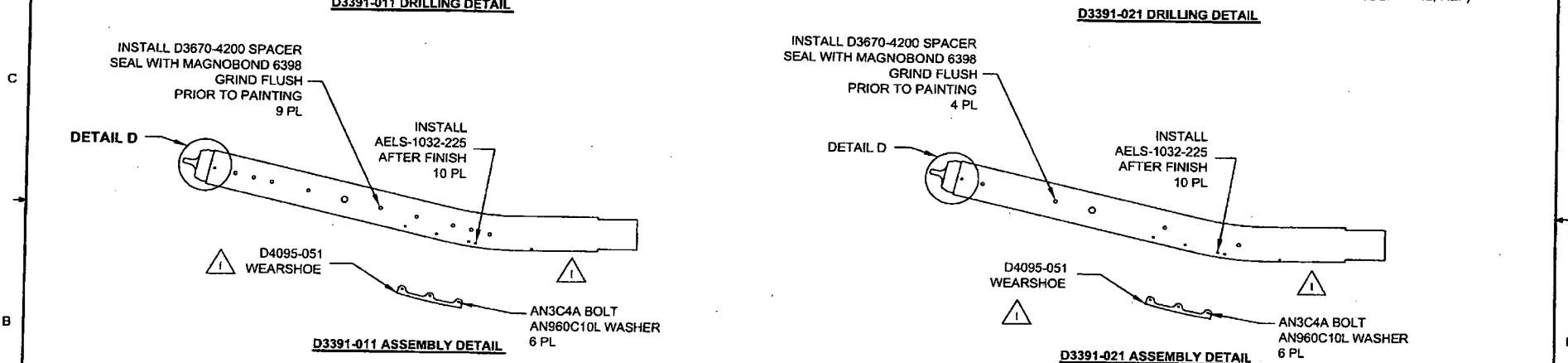
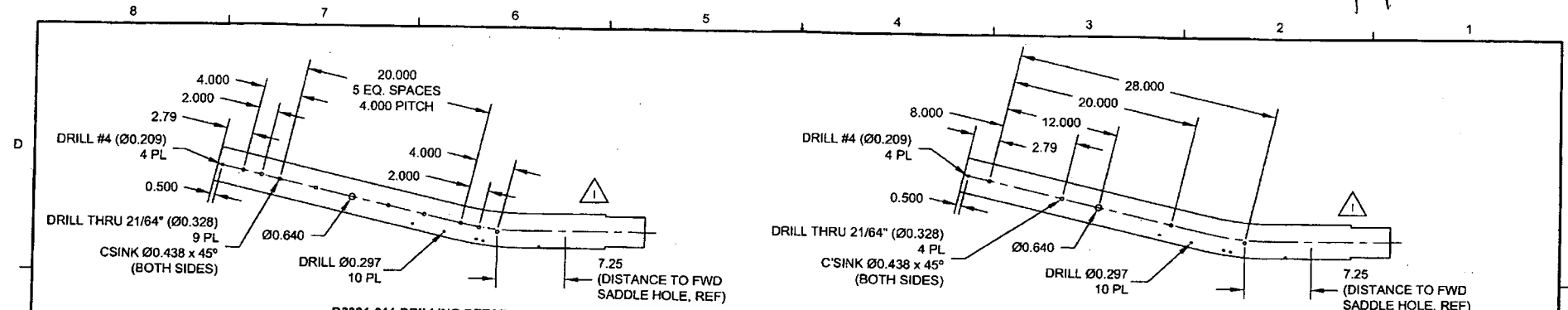
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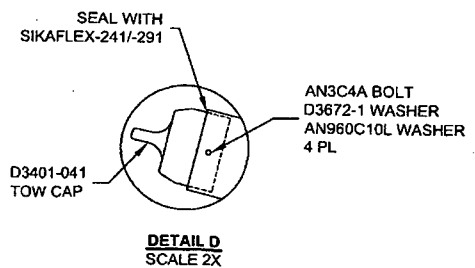
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D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST

QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X		D3391-011	FWD TUBE ASSEMBLY
	X	D3391-021	FWD TUBE ASSEMBLY
1	1	D3401-041	TOW CAP
9	4	D3670-4200	SPACER
4	4	D3672-1	WASHER
1	1	D4095-051	WEARSHOE
1	1	D6013-047	FWD TUBE
10	10	AN3C4A	BOLT
10	10	AN960C10L	WASHER
10	10	AELS-1032-225	INSERT



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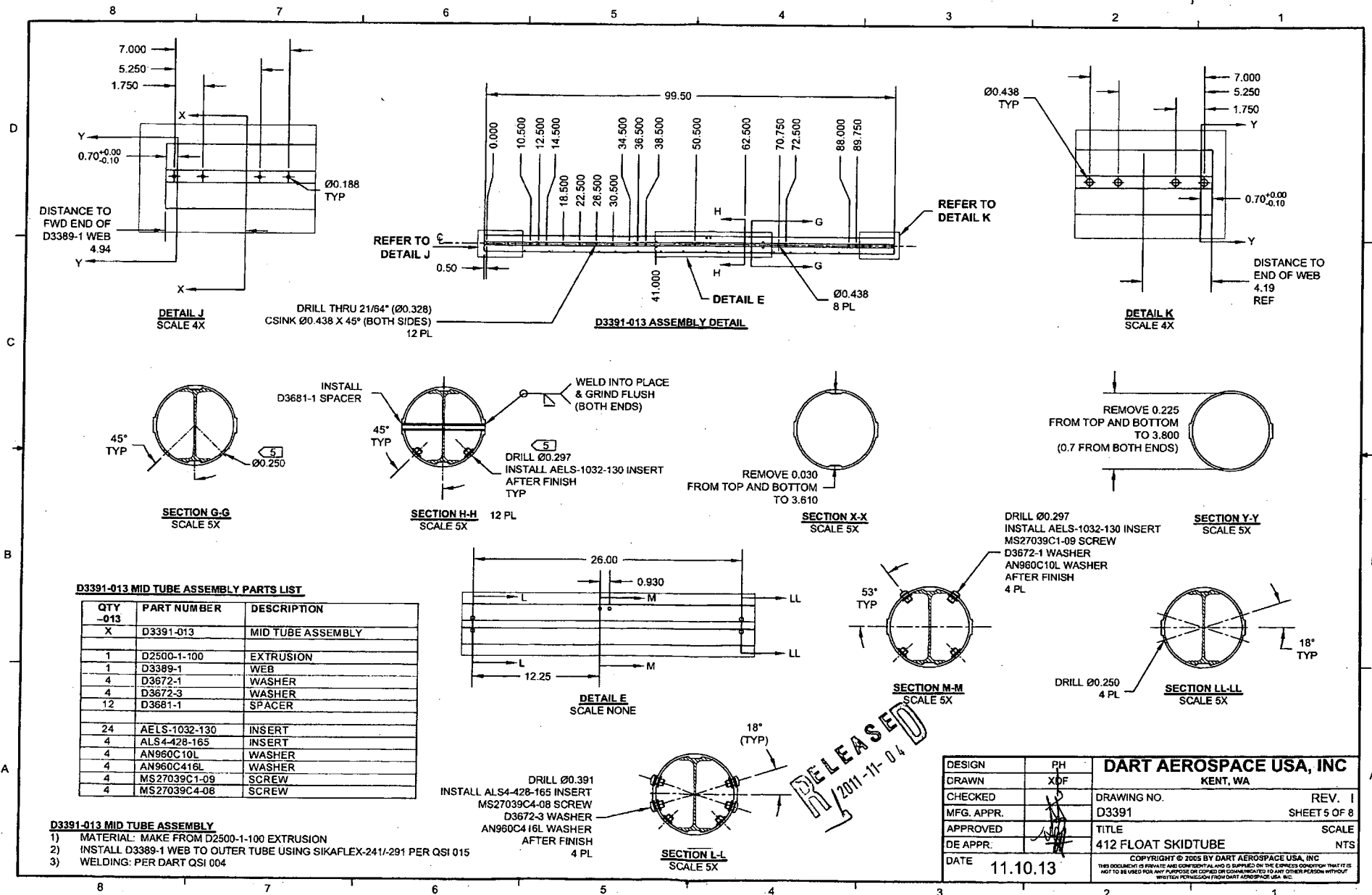
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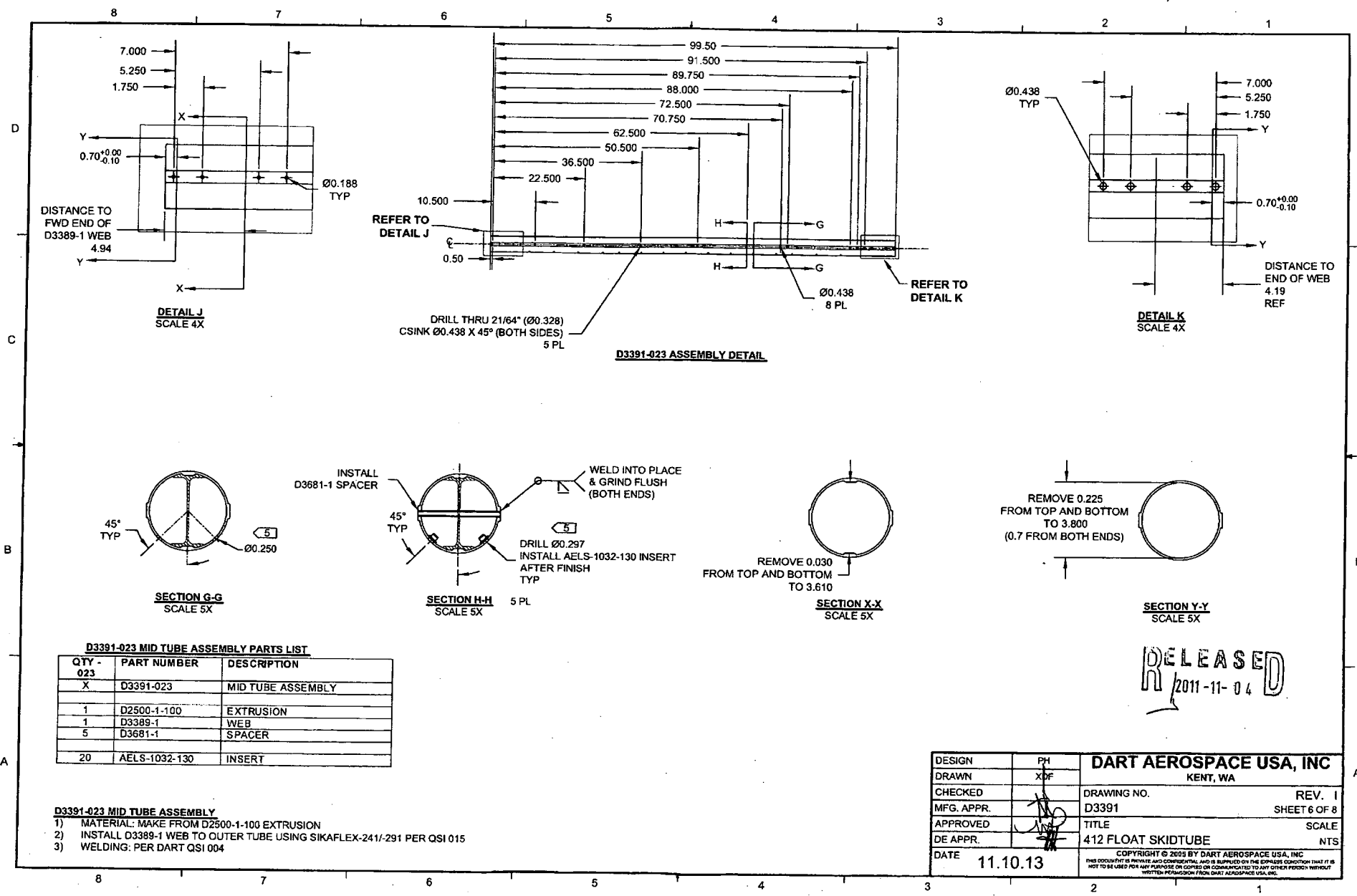
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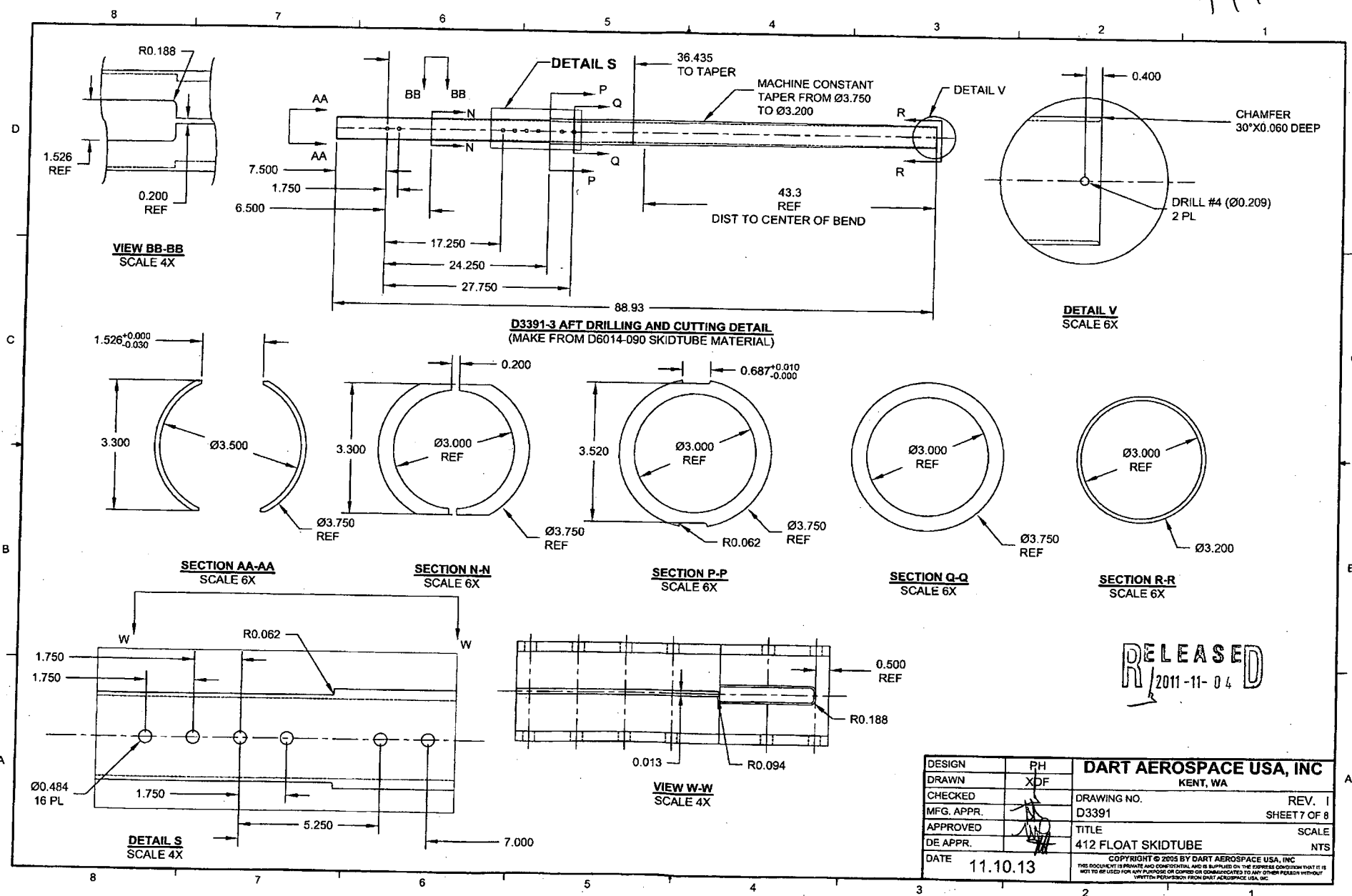
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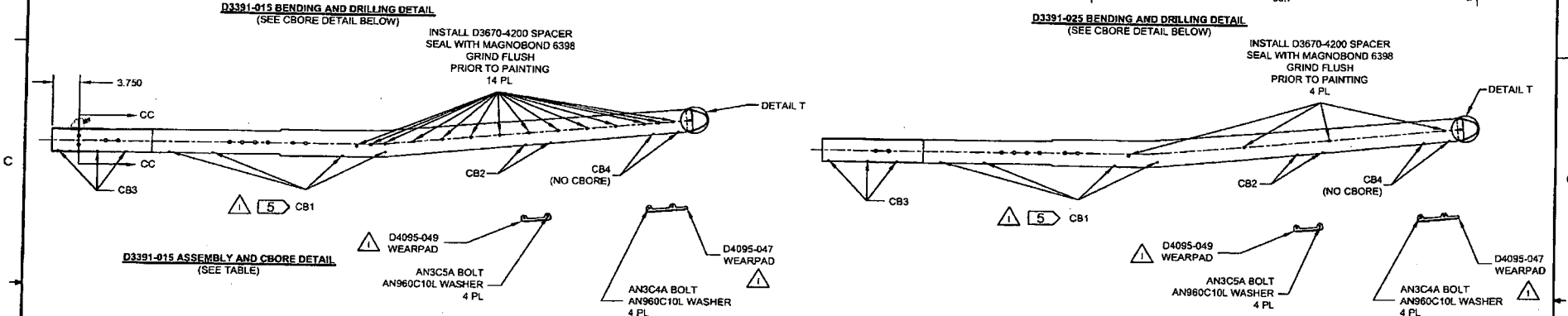
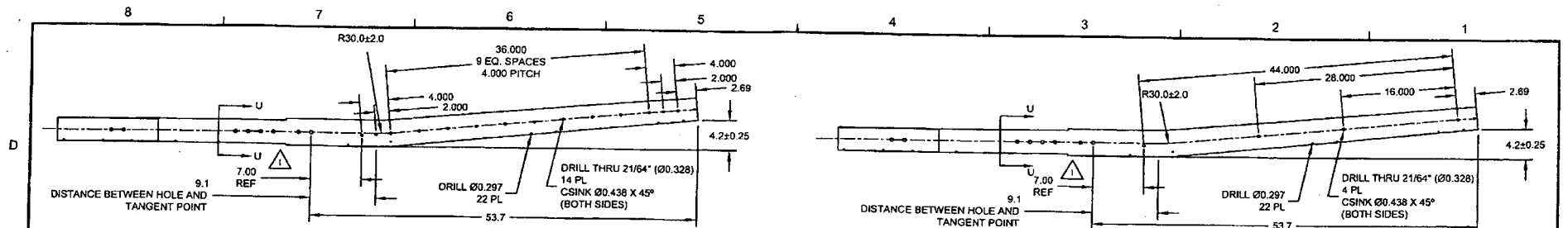
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

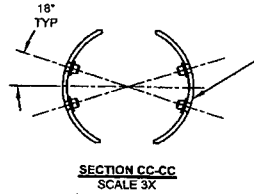
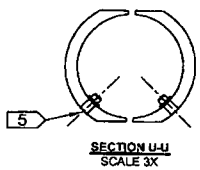
NOTE: Date & initial all entries

79950

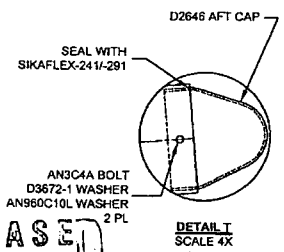


D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
		D3391-025	AFT TUBE ASSEMBLY
1	1	D2646	AFT CAP
14	4	D3670-4200	SPACER
2	2	D3672-1	WASHER
1	1	D4095-049	WEARPAD
1	1	D4095-047	WEARPAD
1	1	D6014-090	AFT TUBE
14	14	AELS-1032-130	INSERT
8	8	AELS-1032-225	INSERT
4	4	ALS4-428-165	INSERT
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
10	10	AN960C10L	WASHER



DRILL Ø0.391
CBORE Ø0.516 X 0.040 DEEP
INSTALL ALS4-428-165 INSERT
4 PL



RELEASED
2011-11-04

CBORE HOLES MARKED CB1-CB4 AS FOLLOWS AND
INSTALL AELS-1032-XXX AFTER FINISH AS NOTED

HOLES MARKED	QTY D3391-015	QTY D3391-025	CBORE	P/N
CB1	8	8	Ø0.430 X 0.170	AELS-1032-225
CB2	4	4	Ø0.430 X 0.170	AELS-1032-130
CB3	6	6	Ø0.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	XOF	KENT, WA	
CHECKED		DRAWING NO.	REV. 1
MFG. APPR.		D3391	SHEET 8 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	11.10.13	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries